

Work Order ID 137083

137083

Page 1

Thursday, September 24, 2015 2:08:15 PM

Item ID: D3684-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mount Assembly
 Start Date: 9/23/15 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: MJ Date: SEP 25 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3684	E

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

3 27 9-23 OCT 19 2015

110	Small Fab	0.00							
110									
Small Fab	Memo	0.16							
Small Fab	1-Align the pilot holes in mating parts. Drill out each hole using pilot drill and ream each hole using a step reamer. Clean and deburr all holes prior to assembly AS PER DWG. (SEE NOTE 8)								
	2-Assemble D3684-049/-047 & D3687-1 Using Hysol EA934NA or MAGNOBOND 6398 adhesive between mating surfaces as per Dwg D3684								

3 FF OCT 19 2015 M131581

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 137083

137083

Page 2

Thursday, September 24, 2015 2:08:15 PM

Item ID: D3684-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mount Assembly
Start Date: 9/23/15 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 9/23/15 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120						(3)			JAS 38 9-89
QC	Memo	0.00							OCT 20 2015
Quality Control									
130	Identify as per dwg & Stock Location: <u>ST 230</u>	0.00							
130						3			
Packaging	Memo	0.00							BAS 27 9-89
Packaging									
									OCT 20 2015
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									MCS OCT 21 2015

SLA 20151020

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

Thursday, September 24, 2015 2:08:15 PM

Page 1

Work Order ID: 137083

137083

Parent Item: D3684-043

D3684-043

Parent Item Name: Mount Assembly

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified
 By:DD IPP REV:D
 13.01.24 PER ECN12-693 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3687-1		Manufactured	No			110	Each	8.0000	1	3			
D3687-1										**	FF	OCT 19 2015	
Mount													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			8						
				102533			7						
				113924			1						
D3684-047		Manufactured	No			110	Each	5.0000	1	3			
D3684-047										**		BAS	
Fwd Leg Assembly												27	
												9-89	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST231			5						
				102870			1						
				122956			2						
				128434			1						
				130938			1						
D3684-049		Manufactured	No			110	Each	3.0000	1	3			
D3684-049										**		BAS	
Aft Leg Assembly												27	
												9-89	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST231B			3						
				122958			2						
				128435			1						
												OCT 19 2015	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____							
Misidentified ☐	☐	Past Due ☐									

Picklist Print

Thursday, September 24, 2015 2:08:15 PM

Work Order ID: 137083

137083

Parent Item: D3684-043

D3684-043

Parent Item Name: Mount Assembly

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 3.00

Required Qty: 3.00

HL32PB8-14

Purchased

No

110

Each

130.0000

4

12

HI 32PB8-14

Replacement Hi-Lok Pin

BAS

27

9-89

Location

Loc Qty

Loc Code

ST554

130

125436

2

m128179

28

m128454

100

12

Scrap 1

HL86-8

Purchased

No

110

Each

141.0000

4

12

HI 86-8

Collar

BAS

27

9-89

OCT 19 2015

Location

Loc Qty

Loc Code

st555

141

m127815

41

m131803

100

12

DQA:

Date: 15/11/23



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/11/12

Work Order update only ☐

Work Order: <u>137083</u> Part No. <u>D 3684-043</u> NCR No. <u>15-5428</u>		DISPOSITION Rework ☒ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☒ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>15-10-19</u>		Step #: <u>110</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				DAS <u>9</u> <u>15-10-29</u> Completed By <u>9</u> <u>OCT 19 2015</u> Lead hand / Supervisor Approval Verification <u>9</u> <u>OCT 19 2015</u> QC / QA Coordinator Approval <u>OCT 19 2015</u> <u>9</u> <u>OCT 19 2015</u>	
<u>1' H 632 PR 8-14 thread was damaged</u> <u>Scrap & destroy</u>				<u>replace Hi-Lok Pin</u>					
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☒ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☒ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☒ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mis-labeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐							
		OTHER: ☐							